

Date: Monday, 2/4/2008 11:25:28 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PEDAL ASSEMBLY
 Job Number : 37168
 Estimate Number : 11005
 P.O. Number :
 This Issue : 2/4/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D412704041
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D412-704-041 REV A
 Previous Run : 36527 Drawing Revision : A
 Material :
 Due Date : 2/28/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:B 05.01.28 Removed hardware on Step 2; Added
 Figures 1-3 KJ/RF
 Est Rev:C 06.03.08 Re-format EC
 Est Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20
 JLM
 Est Rev:E 07.05.02 Reformat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3204041 Pedal Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch
 1 D3204-041 Pedal Assembly B37169

mf

2.0 D32051 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch
 1 D3205-1 Bracket B34238

mf

3.0 D32053 Back Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch
 1 D3205-3 GHW Bracket 32823
 B328912 x ①, B35209 x ③

mf

4.0 D32061 Pedal Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch
 B36535 x ①, B34239 x ③

mf

08-0207

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 37168

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1

D3206-1

Pedal arm

B 36535A, B 34239 (S)

5.0

D3209041

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3209-.041	Bracket	<i>B30832</i>

mf.

6.0

AN310A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN3-10A	Bolt	<i>M17566</i>

mf.

7.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN315-4R	Nut	<i>M17566</i>

mf.

8.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-10A	Bolt	<i>M105442</i>

mf.

9.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description	batch
2	AN4-12A	Bolt	<i>M105143</i>

mf 08-02-07

Dart Aerospace Ltd

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Seq. #:

Machine Or Operation:

Description :

10.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-13A	Bolt	m106815

mf.

11.0

AN960JD10

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	AN960JD10	Washer	m106167

mf

12.0

AN960JD416

Washer



Comment: Qty.: 11.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part number	Description	batch
11	AN960JD416	Washer	m106780

mf

13.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part number	Description	batch
3	AN960JD416L	Washer	m106785

mf.

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS21042L3	Nut	m105558

mf.

15.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	MS21042L4	Nut	m105938

mf 08-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Machine Or Operation:

Description :

16.0

MS24694S102

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS24694S102	Screw	<u>m14604</u>

mf

17.0

MS951910

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS9519-10	Bolt	<u>M100290</u>

mf 08-02-07

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041

mf 08-02-07 (4)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/02/08 (4)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part number	Description	batch
4	AN960JD10L	Washer	<u>M104825</u>

8/2/8 50 (4X)

W/O:		WORK ORDER CHANGES					
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Machine Or Operation:

Description :

22.0

AN36A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part number

Description

batch

2

AN3-6A

Bolt

M106586

5d

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch:

M105558

8/2/8

5d

(4)

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/02/11 (4)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 201

AS 08/02/11

(4)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.02.13
KJ

Job Completion



2008/2/11

(4)

U

Dart Aerospace Ltd

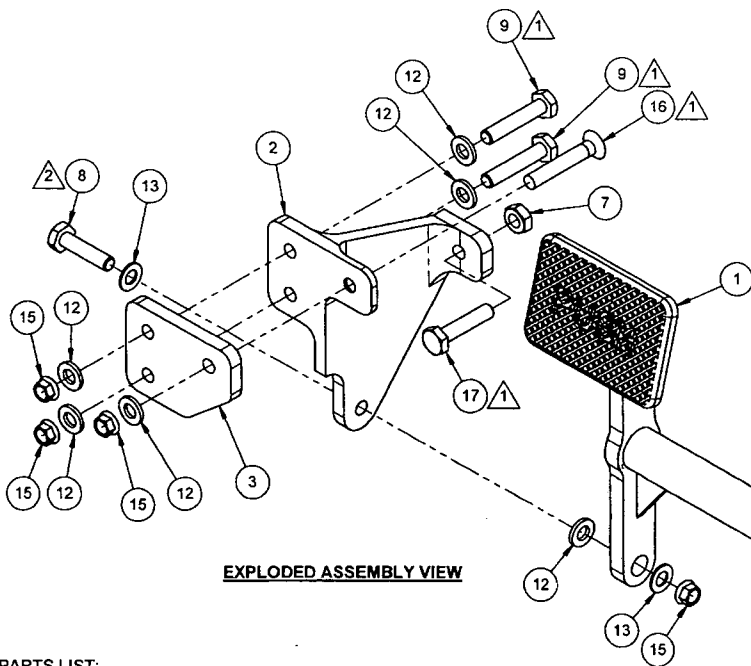
W/O:		WORK ORDER CHANGES					
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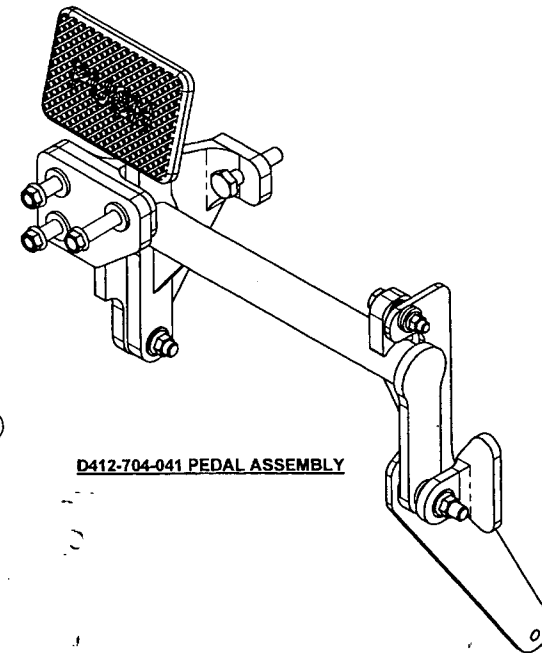
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EXPLODED ASSEMBLY VIEW



D412-704-041 PEDAL ASSEMBLY

PARTS LIST:

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NOTES:

- 1 INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2 TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3 TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

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WITHOUT NOTICE

RELEASED

07.01.23

A	REV	07.01.23	NEW ISSUE	DESCRIPTION
DESIGN	CB	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	DATE	DRAWING NO. D412-704-041
DATE	07.01.23	TITLE	SCALE	REV. A SHEET 1 OF 1 1:2
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